

CLAIMS

1. A collapsible container, manufactured through injection-molding from plastic having integrated hinges, wherein the sidewalls are pivotally connected to each other and to the bottom and wherein at least two sidewalls of the container are foldable.
- 5 2. A collapsible container according to claim 1, provided with a bottom, and at least two first sidewalls arranged opposite each other and two second sidewalls arranged opposite each other, the first and second walls being connected to the bottom via first hinging elements, while each time, a first sidewall is connected to a second sidewall by at least a second hinging element,
10 wherein in at least two first sidewalls hinging elements are provided, such that the first sidewalls can be folded together at least partly and the second sidewalls can be pivoted in the direction of the bottom for folding up the container.
3. A collapsible container according to claim 1 or 2, wherein in the first
15 sidewalls, by second hinging elements and third hinging elements, substantially triangular wall surfaces are bounded.
4. A collapsible container according to claim 3, wherein at least one fourth hinging element is provided, extending, with the container in folded-out condition, approximately at right angles to the bottom surface, and at least two
20 third hinging elements extending from near the intersection between the bottom surface and the or a third hinging element, which include an angle with said bottom and said fourth hinging element and extend at least to a point near the adjacent second hinging element, while fourth hinging elements located in the oppositely located first sidewalls are interconnected by a fifth
25 hinging element located in the bottom.
5. A collapsible container according to claim 4, wherein in each first wall one fourth hinging element is provided, while two third hinging elements

extend in opposite directions from the intersection of the bottom surface and the respective fourth hinging element, such that the respective first sidewall comprises at least one substantially triangular first wall surface on both sides of the fourth hinging element, enclosed by a second hinging element and a first hinging element or a fourth hinging element, while, moreover, on both sides of the fourth hinging element a second wall surface is provided, at least bounded by the respective fourth hinging element and a third hinging element.

6. A collapsible container according to claim 5, wherein each first wall surface is substantially an equilateral triangle.
- 10 7. A collapsible container according to claim 5 or 6, wherein each second wall surface is substantially a quadrangle and in particular has a trapezium-shape.
8. A collapsible container according to claim 5 or 6, wherein each first and each second wall surface is substantially triangular, in particular in the shape of an equilateral triangle.
- 15 9. A collapsible container according to any one of the preceding claims, wherein in the bottom at least a fifth hinging element is included, which substantially extends along a line between fourth hinging elements and/or intersections between third hinging elements and first hinging elements.
- 20 10. A collapsible container according to claim 9, wherein in the bottom surface contiguous to the first hinging element, at the first sidewalls, two first bottom surfaces are bounded each by a sixth hinging element, the respective first hinging element and the fifth hinging element.
- 25 11. A collapsible container according to claim 10, wherein the first bottom surfaces are substantially triangular, in particular have the shape of an equilateral triangle.
- 30 12. A collapsible container according to any one of claims 9 or 11, wherein near each first sidewall, in the bottom, two first bottom surfaces are provided, each bounded by at least a sixth hinging element, which sixth hinging elements intersect at an intersection on the line along which the fifth

hinging element substantially extends, while between the thus formed two intersections a part of the fifth hinging element is located.

13. A collapsible container according to any one of the preceding claims, wherein at least a number of hinging elements are living hinges, the hinging
5 elements being at least liquid-tight, the arrangement being such that the container, at least in folded-out position, can contain liquid.

14. A collapsible container according to any one of the preceding claims, wherein at least a number of hinging elements are film hinges, the hinging
10 elements being at least liquid-tight, the arrangement being such that the container, at least in folded-out condition, can contain liquid.

15. A collapsible container according to any one of the preceding claims, wherein the hinges are placed and designed such, while the direction of hinging is defined such, that the outside of the container, at least at the location of the hinging elements, is substantially flat, at least smooth.

15 16. A collapsible container according to any one of the preceding claims, wherein the hinges are placed such and designed such, while the direction of hinging is defined such, that the inside of the container, at least at the location of the hinging elements, is substantially flat, at least smooth.

17. A collapsible container according to any one of the preceding claims,
20 wherein the first and second walls are foldable such that they remain within the contours of the bottom.

18. A collapsible container according to any one of the preceding claims, wherein the bottom is somewhat convex, at least truncated cone- or pyramid-shaped in the direction of the inside space of the container in folded-out
25 condition.

19. A mold for injection molding a collapsible container, wherein the mold comprises at least one mold cavity, provided with a bottom forming part and at least four sidewall forming parts, each of the sidewall forming parts being connected to the bottom forming part via first hinging element forming
30 parts and to at least two other sidewall forming parts via second hinging

element forming parts, while in at least two sidewall forming parts means are provided for forming third hinging elements, which extend at an inclination relative to the first and second hinging element forming parts.

20. A mold according to claim 19, wherein at least one core is provided
5 between the sidewall forming parts, and at least the means for forming the second hinging elements extend at least partly from the core in the respective sidewall forming parts and are arranged so as to be moveable.

21. A method for forming a collapsible container provided with a bottom
10 an at least four sidewalls hingedly connected thereto, which sidewalls are hingedly interconnected, while a mold with at least one mold cavity is used having the shape of the folded-out container, into which mold cavity plastic is introduced with the aid of injection-molding technique, such that in the at least one mold cavity a collapsible container in folded-out condition is
15 injection-molded, while in at least two sidewalls located opposite each other hinging elements are integrally formed, such that the respective sidewalls are foldable.